

Work Order ID 54874

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Page 1

Item ID: D3684-049

Accept

Revision ID:

Item Name: AFT LEG ASS'Y

Start Date: 1/5/2010

Start Qty: 1.00

Required Date: 1/18/2010

Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-01-04 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3684

Rev C

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

SB 10/01/25

3

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684

2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684

***Ensure holes for AN3C Bolts are free of sealant.
Torque Fastners as per Dwg D3684

SB 10/01/25

3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Item ID: D3684-049

Accept

Setup Start

Revision ID:

Stop

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Start Date: 1/5/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 1/18/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 8106125

(X3)

130

Identify as per dwg & Stock Location: 78

0.00



Packaging

Memo

0.00

Packaging

10-1-25

3x 20

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/26

MF 10-1-25

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Picklist Print

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Work Order ID: 54874

Parent Item: D3684-049

Parent Item Name: AFT LEG ASS'Y


Comments:

Start Date: 1/5/2010

Required Date: 1/18/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C12A  Bolts		Purchased	No			110	Each	350.0000	2.0000 6			

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

350

112314

350

D3688-3

Manufactured

No

110

Each

22.0000

3.0000

STUD

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

22

44824

6

50936

2

51297

14

D3689-1

Manufactured

No

110

Each

21.0000

1.0000

SLEEVE

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

2

46051

2

Main Warehouse

ST125

19

50745

19

SB 10/01/25

SB 10/01/25

SB 10/01/25

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Parent Item Name: AFT LEG ASS'Y

Start Date: 1/5/2010

Required Date: 1/18/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3691-1 		Manufactured	No			110	Each	0.0000	1.0000	③		
STUD						B 54859						
D3692-1 		Manufactured	No			110	Each	642.0000	1.0000	12.		
SPACER												

SN 10/01/25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST	55	
44827	8	
45672	14	
50325	33	

Main Warehouse

ST127	587	
50736	179	
51467	408	

SN 10/01/25

12

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Comments:

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3693-1  Rod End Bearing		Manufactured	No			110	Each	73.0000	73 0000 			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 5

45723 5

Main Warehouse

ST127 68

50733 7

50734 61


MS21043-3

Purchased

No

110

Each

4,542.000 ~~2~~0000


Nut

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG 80

103691 80

Main Warehouse

ST 4462

111819 70

112243 29

112314 4363

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Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS509-12C 		Purchased	No			110	Each	126.0000	3/1.0000			
Nuts												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	126	
106993	7	
110844	10	
112453	109	

NAS509L12C 		Purchased	No			110	Each	85.0000	3/1.0000			
Nuts												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	85	
106993	2	
112314	73	
112828	10	

83
10/01/25

83
10/01/25

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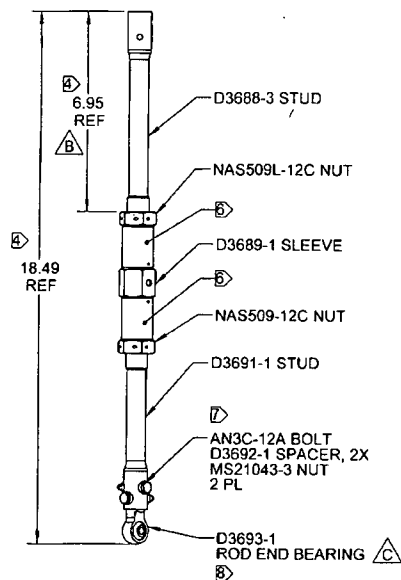
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ITEM	QTY .049	PART NUMBER	DESCRIPTION
1	X	D3684-049	AFT LEG ASSEMBLY
2	1	D3688-3	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT







D3684-049 AFT LEG ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 2.88 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

RELEASED
09/01/12

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3684	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
DATE	08.12.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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